

Work Order ID 91428

91428

Page 1

Item ID: D4541-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 10/10/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12-10-10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4541

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg(CUT D4541-5)

Prog rev: E

Dwg rev: E

2- Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10

B12-11-5

10

B12-11-5

Work Order ID 91428

91428

Page 2

October-10-12 9:08:03 AM

Item ID: D4541-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 10/10/2012 Start Qty: 15.00 ***15***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00 ***15***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC8- Inspect parts - second check

0.00

120

QC Memo

0.00

Quality Control

125

0.00

125

Small Fab Memo

0.00

Small Fab BEND TABS PER DWG

127

QC5- Inspect part completeness to step on W/O

0.00

127

QC Memo

0.00

Quality Control

Abdine

QC

15
12/11/19

15 12/11/19

15

Work Order ID 91428

October-10-12 9:08:03 AM

91428

Page 3

Item ID: D4541-6

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 10/10/2012 Start Qty: 15.00 ***15***

Cust Item ID:

Required Date: 10/12/2012 Req'd Qty: 15.00 ***15***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: <u>St 163</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 15 | | | 12/11/21 JB |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/11/22 JB

CMF
12-11-21

Picklist Print

October-10-12 9:08:08 AM

Page 1

Work Order ID: 91428

91428

Parent Item: D4541-6

D4541-6

Parent Item Name: Bracket

Start Date: 10/10/2012

Required Date: 10/12/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.05.08 as per dwg revC DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.032 | | Purchased | No | | | 100 | sf | 700.0600 | 0.3606 | 5.693684 | | | |

M6061T6S 0.32

6061-T6 Sheet 0.032"

**

B/L-11-5

Location

Loc Qty

Loc Code

MAT021

700.06

121099

85.97

122256

40.89

122737

30.1

123097

91.1

123135

96

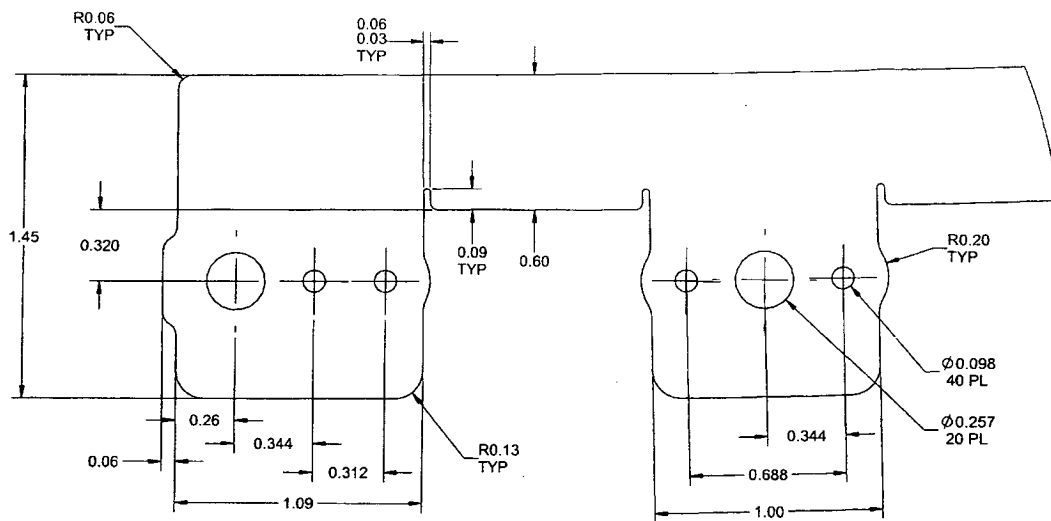
123137

356

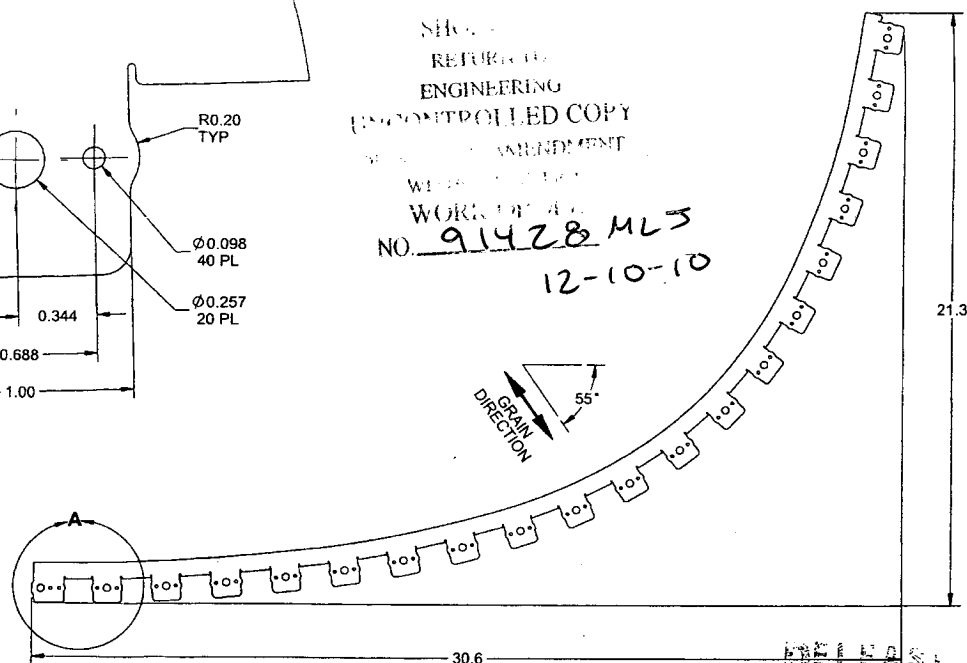
15

~~12348~~

123483



DETAIL A
TYP TAB DETAIL
SCALE 8X



D4541-1 BRACKET

RELEASE
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-1-REVC.DXF"

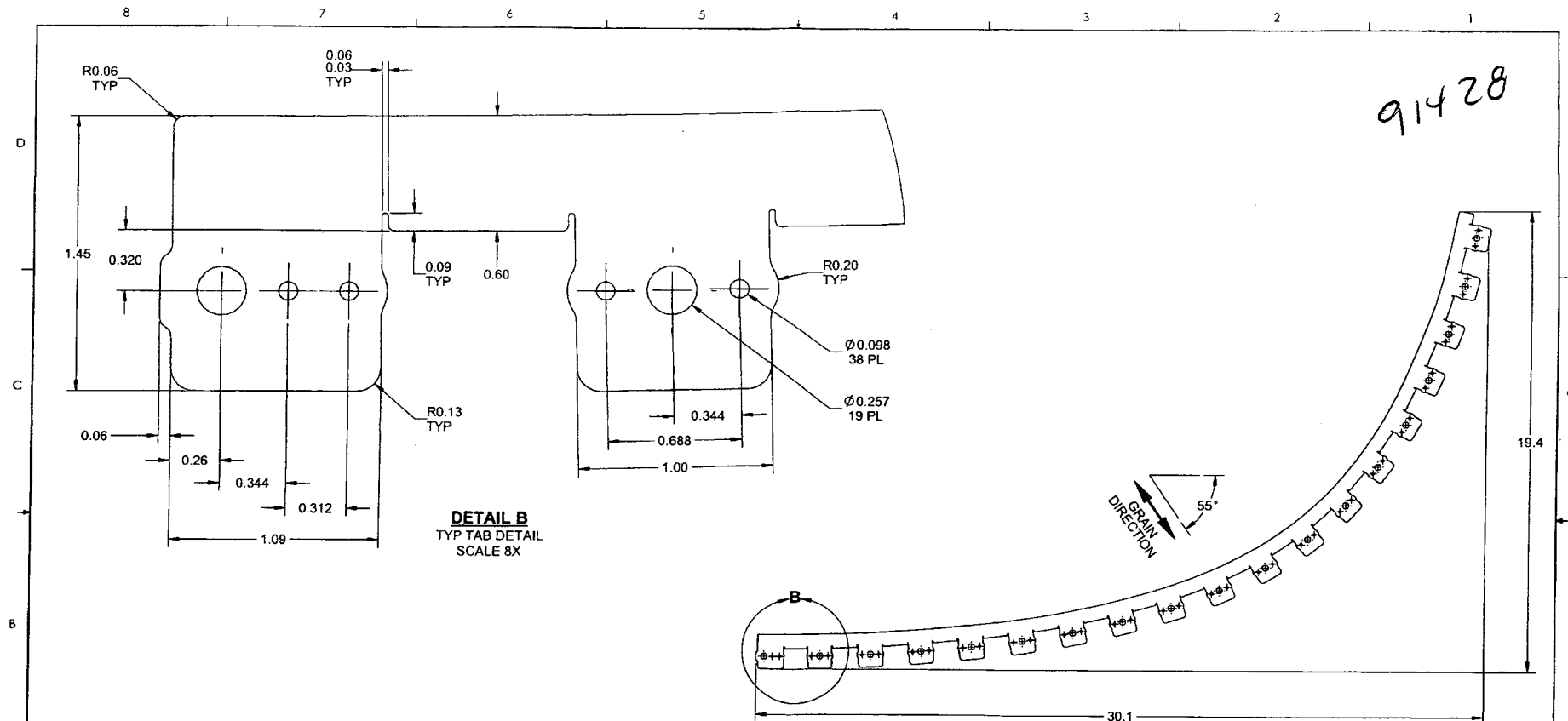
| C | D4541-5F WAS -5; ADD -5/6; RMV FINISH (-1/2/-3/-5/-7); 0.70 WAS 0.60 (ZN D1-3) | CP | 12.04.20 |
|------------|---|----|----------|
| B | -5: 1.55 WAS 1.45 (ZN C4-4) | CP | 12.02.01 |
| A | NEW ISSUE | CP | 12.01.09 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JP | | |
| DRAWN | JP | | |
| CHECKED | ASS | | |
| MFG. APPR. | JP | | |
| APPROVED | JP | | |
| DE APPR. | JP | | |
| DATE | 12.04.20 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4541
REV. C
SHEET 1 OF 7
SCALE
NTS

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSES OR COMPARISONS UNLESS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD

91428



D4541-2 BRACKET

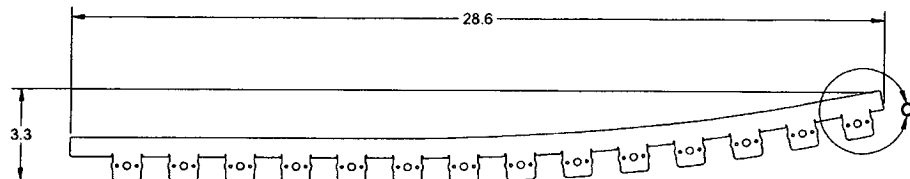
RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-2-REVC.DXF"

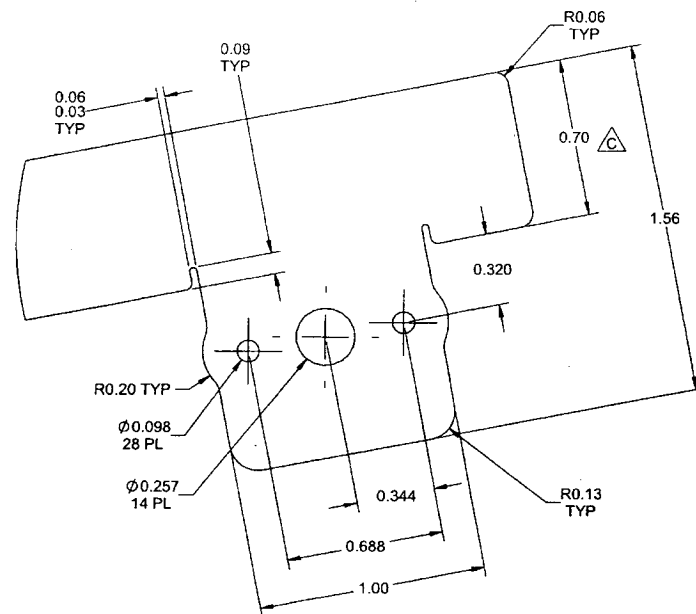
| | | | | |
|---|----------|---|-------------|--------------|
| DESIGN | | DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA | | |
| DRAWN | | | | |
| CHECKED | | | DRAWING NO. | REV. C |
| MFG. APPR. | | | D4541 | SHEET 2 OF 7 |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | BRACKET | NTS |
| DATE | 12.02.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD | | |
| THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | | | | |

91428



D4541-3 BRACKET

GRAIN
DIRECTION



DETAIL C
TYP TAB DETAIL
SCALE 4X

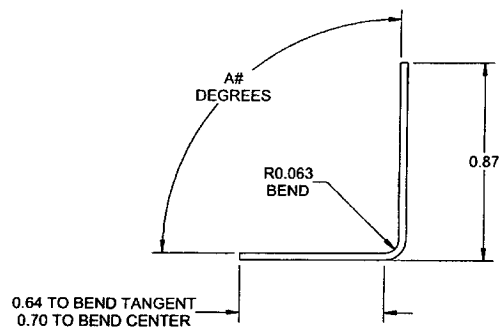
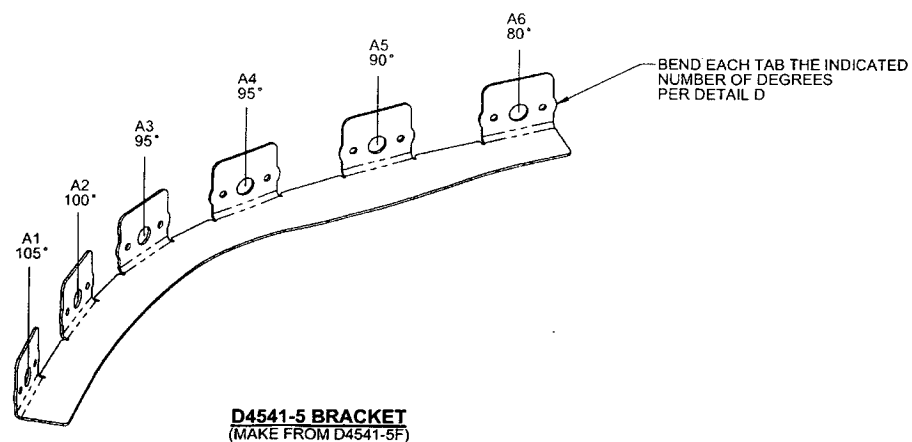
RELEASED
2012-05-07
JMD

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs
- 8) PROFILE PER DRAWING FILE "D4541-3-REVC.DXF"

| | | | |
|---|----------|--|--------------|
| DESIGN | 40 | DART AEROSPACE LTD | |
| DRAWN | 40 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. C |
| MFG. APPR. | | D4541 | SHEET 3 OF 7 |
| APPROVED | JMD | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
| DATE | 12.02.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

91428



DETAIL D
BEND DETAIL
SCALE 2X

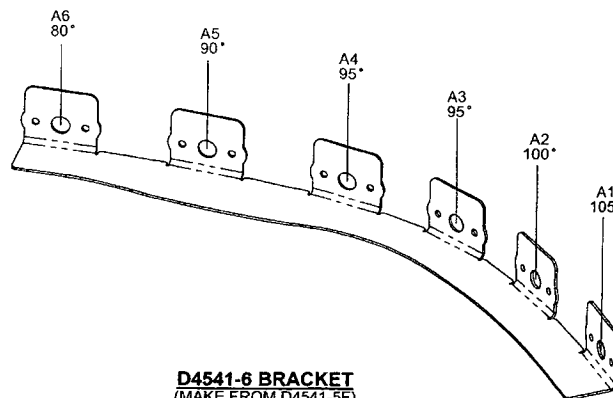
NOTES:

- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SS | DRAWING NO. | REV. C |
| MFG. APPR. | | D4541 | SHEET 4 OF 7 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
| DATE | 12.02.20 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

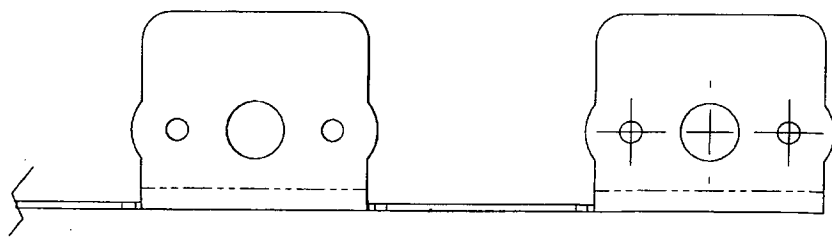
RELEASED
2012-05-07

91428

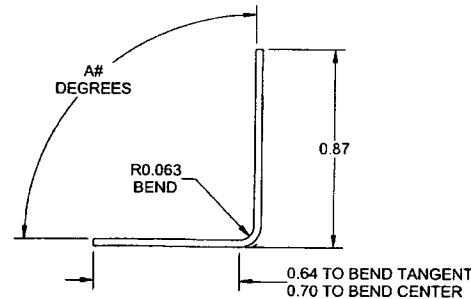


D4541-6 BRACKET
(MAKE FROM D4541-5F)

BEND EACH TAB THE INDICATED
NUMBER OF DEGREES
PER DETAIL E



DETAIL E
BEND DETAIL
SCALE 2X



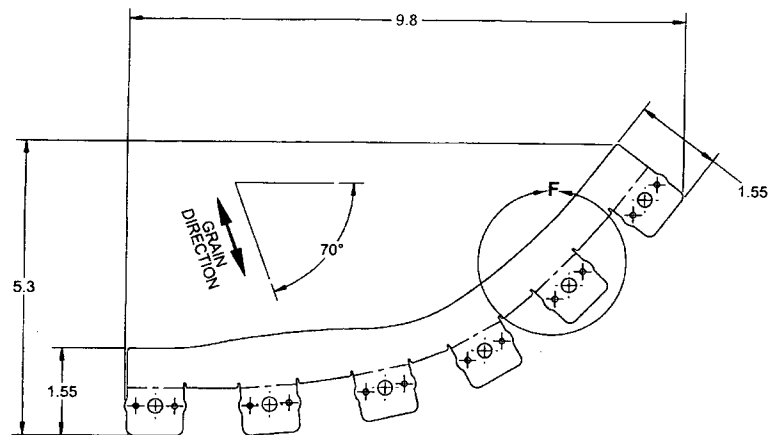
RELEASED
2012-05-07

NOTES:

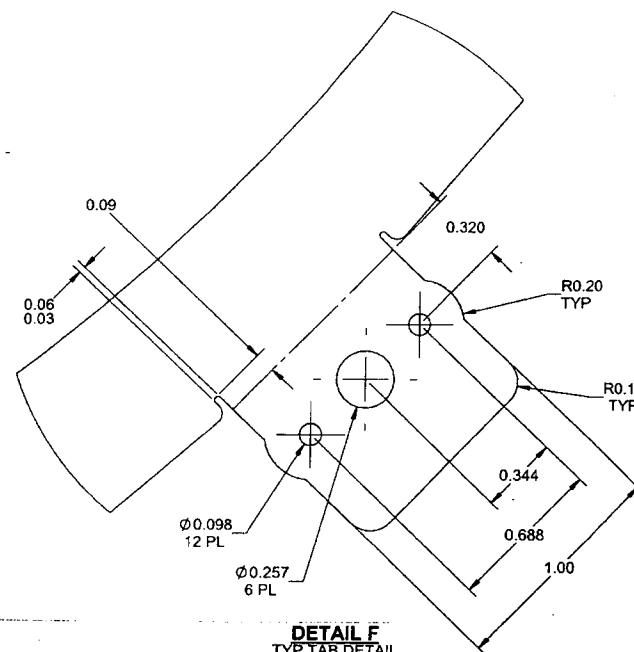
- 1) MATERIAL: MAKE FROM D4541-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. C |
| CHECKED | ASS | D4541 | SHEET 5 OF 7 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | BRACKET | NTS |
| DE APPR. | | COPYRIGHT © 2012 BY DART AEROSPACE LTD | |
| DATE | 12.02.20 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

91428



D4541-5F FLAT PATTERN







DETAIL F
TYP TAB DETAIL
SCALE 4X

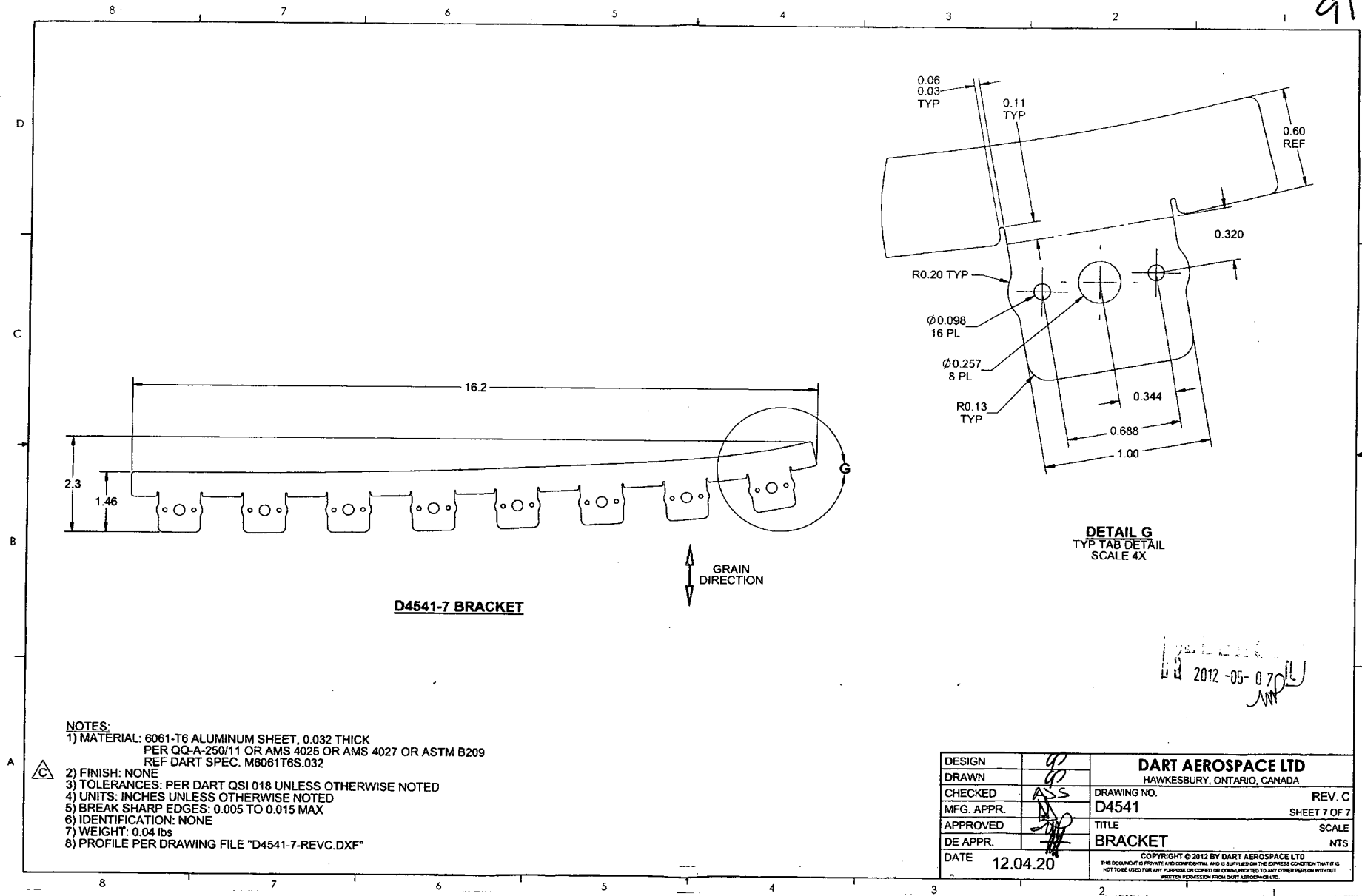
RELEASE
2012-05-07
AN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4541-5-REVC.DXF"

| | | | |
|--|---|--|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. C |
| MFG. APPR. |  | D4541 | SHEET 6 OF 7 |
| APPROVED | | TITLE | SCALE |
| DE APPR. |  | BRACKET | NTS |
| DATE | 12.04.20 | COPYRIGHT © 2012 BY DART AEROSPACE LTD | |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | | | |

91428



DETAIL G
TYP TAB DETAIL
SCALE 4X

2012-05-07
JMP

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.04 lbs
 - 8) PROFILE PER DRAWING FILE "D4541-7-REVC.DXF"

| | | | |
|------------|----------|---|--------------|
| DESIGN | g | DART AEROSPACE LTD | |
| DRAWN | g | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | ASS | DRAWING NO. | REV. C |
| MFG. APPR. | | D4541 | SHEET 7 OF 7 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
| DATE | 12.04.20 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |